



Dart Aerospace Ltd.
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DSK076

Job Sheet 187533



Part No: DSK076

Job Qty: 10 ea

Part Name: D2891-1 Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/6/18

Job Tracking No:

Due Date: 12/14/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV A IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Machining-4		
100	Doosan	10 pcs	12/14/18	12/14/18	0.06	6.71	Doosan		
110	QC	10 pcs	12/14/18	12/14/18	0.00	0.00	QC2 Machining-4		
120	QC	10 pcs	12/14/18	12/14/18	0.00	0.00	QC8 Machining-4		
130	Packaging	10 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-2		
140	QC21-SA	10 Ea	12/14/18	12/14/18	0.00	0.00	QC21		

Part Op 100 - Turn blank for as per Folio FA046 DT8671
Descriptions: 130 - LOCATION: MAT060

JAN 25 2019
21
3-86

hrs
3 1/2 1st op

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6104-003	Round Billet, 17-4	10 Ea (1 ea)	90-Start up Operation	S083252

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6104-003	10	20	0

Part Specifications

Specifications could not be found.



Container No: S144708



Part: DSK076

Job No: 187533

Serial No/Batch: S144708

Revision:

Inspector:

Exp Date:

Instructions:

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Plex 12/6/18 3:51 PM dart.leroux.jason

D6104-003
S083252

Date: 01/14/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 187533
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279	DT8671	2.278	2.278	2.278	2.277	2.278
B	3.702	3.722		3.712	3.711			
C	2.564	2.584		2.5745	2.574			
D	0.718	0.738		.727	.7275			
E	0.090	0.110		.100	.099			
F	2.464	2.484		2.475	2.474			
G	2.029	2.049		2.039	2.039			
H	2.964	2.984		2.975	2.976			
I	0.913	0.933		.922	.922			
J	0.022	0.042		R/.32	R/.32			
K	0.090	0.110		.099	.099			
L								
M								
N								
O								
P								

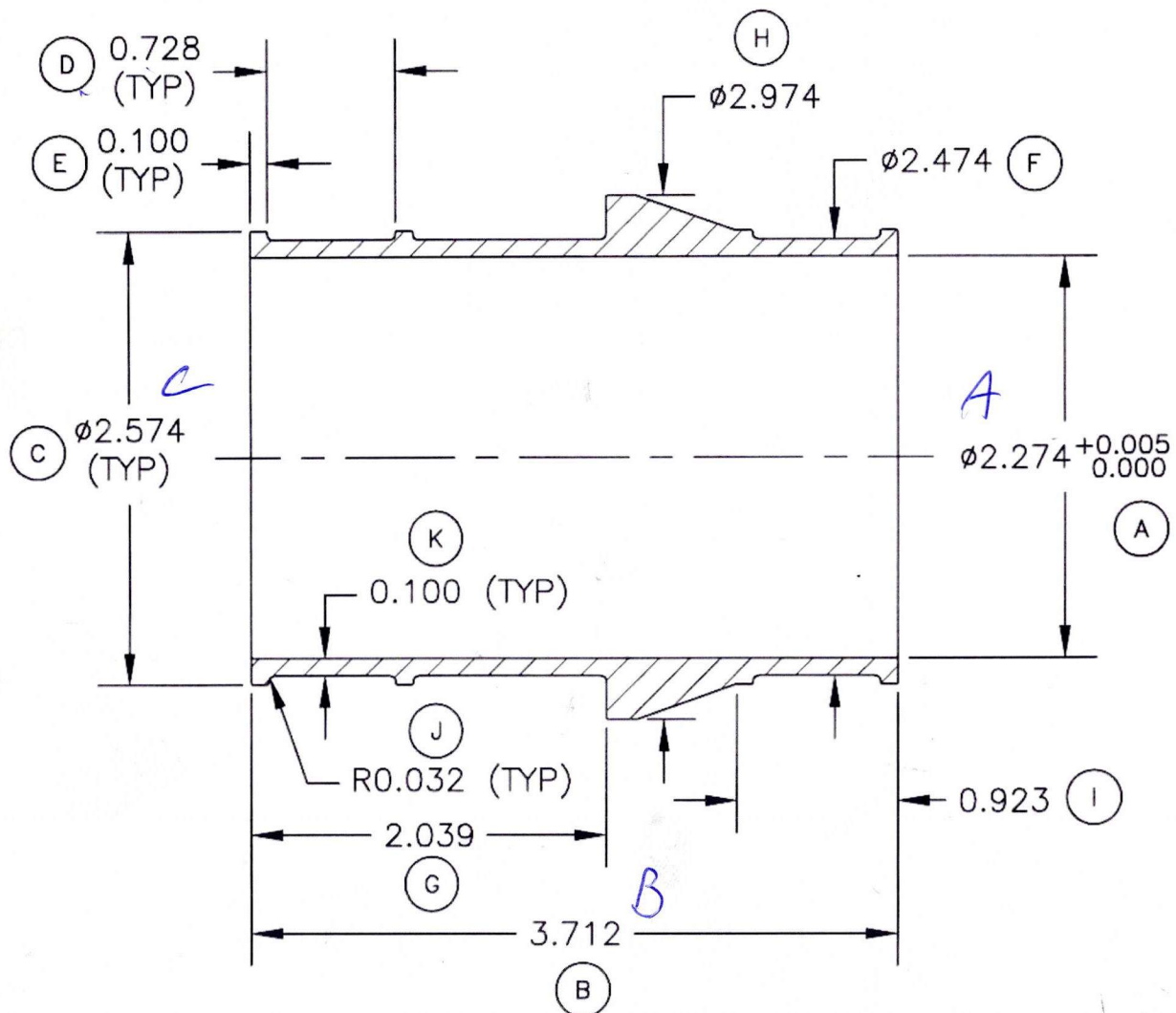
Measured by: DaeC. Se	Date: 19/6/15
Audited by:	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20	TITLE TURNING DETAIL FOR D2891-1		SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



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